

JAPAN

EDICT OF GOVERNMENT

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JIS B 4803 (1998) (English): Bandsaw blades for
woodworking

ISO INSIDE

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*The citizens of a nation must
honor the laws of the land.*

Fukuzawa Yukichi

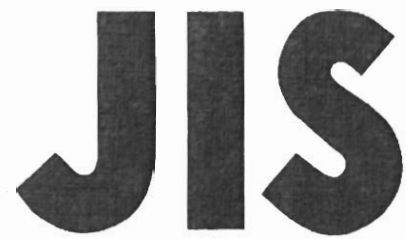
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JAPANESE
INDUSTRIAL
STANDARD

Translated and Published by
Japanese Standards Association

Ⓔ JIS B 4803 : 1998

Bandsaw blades for woodworking

ICS 79.120.20

Descriptors : band saws, woodworking machines, cutting tools, woodworking,
blades

Reference number : JIS B 4803 : 1998 (E)

Foreword

This translation has been made based on the original Japanese Industrial Standard revised by the Minister of International Trade and Industry through deliberations at Japanese Industrial Standards Committee in accordance with the Industrial Standardization Law. Consequently, JIS B 4803:1973 is replaced with JIS B 4803:1998.

This revision is intended to conform to corresponding International Standard, **ISO 3295:1975**, *Narrow bandsaw blades for woodworking — Dimensions* and practical use.

Attention is drawn to the possibility that some parts of this Standard may conflict with a patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have technical properties. The relevant Minister and the Japanese Industrial Standards Committee are not responsible for identifying the patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have the said technical properties.

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Bandsaw blades for woodworking

Introduction This Japanese Industrial Standard was made on the basis of **ISO 3295**, *Narrow bandsaw blades for woodworking — Dimensions* published in 1975 as the first edition, without changing the technical contents except the classes specified conventionally in the Japanese Industrial Standard and the shapes and dimensions corresponding them. Besides, the items not specified in the corresponding International Standard (quality, material, test method, inspection, designation of products and marking) were also added to this Japanese Industrial Standard.

1 Scope This Standard specifies the bandsaw blades for woodworking (hereafter referred to as "bandsaw").

Remarks: The following is the corresponding International Standard to this Standard:

ISO 3295:1975 *Narrow bandsaw blades for woodworking — Dimensions*

2 Normative references The following standards contain provisions which, through references in this Standard, constitute provisions of the Standard. The most recent editions of the standards indicated below shall be applied.

JIS B 7502 *Micrometer callipers*

JIS B 7507 *Vernier, dial and digital callipers*

JIS B 7725 *Vickers hardness testing machines*

JIS G 3311 *Cold rolled special steel strip*

JIS Z 2244 *Method of Vickers hardness test*

3 Quality

3.1 Appearance The appearance shall be free from the defects such as cracks, flaws harmful in use and rust, and the finish shall be good.

3.2 Variation in width and thickness The variation in width and thickness of the bandsaw shall be as given in Table 1.

Table 1 Variation in width and thickness

Unit: mm

Division		Variation (in single bandsaw)	
Width	Thickness	Width	Thickness
127 or under	0.7 or under	0.4 or under	0.05 or under
	0.8 or over		0.06 or under
152 or over	1.05 or under	0.5 or under	0.07 or under
	1.25 or over		0.08 or under

3.3 Hardness The hardness of the bandsaw and variation in hardness shall be as given in Table 2.

Table 2 Hardness

Division of width mm	Hardness HV	Variation in hardness (in single bandsaw) HV
63 or under	320 to 490	50 or under
76 or over	400 to 560	

3.4 Camber The camber of the bandsaw shall be as given in Table 3.

Table 3 Camber

Unit: mm

Division of width	25 or under	32 to 76	102 to 152	178 or over
Camber	15 or under	10 or under	8 or under	6 or under

4 Shape and dimensions The shape and dimensions of the bandsaw shall be as given in Attached Table 1.

5 Materials The materials used for the bandsaw shall be SK6M or SKS5M specified in **JIS G 3311** or the materials equivalent or superior thereto in performance.

6 Test method

6.1 Width and thickness The width shall be measured at any four places using a vernier calliper specified in **JIS B 7507**.

The thickness shall be measured at approximately the middle of the width for the bandsaw of the width not more than 40 mm and at any four places on a line 5 mm to 15 mm inside from the edge surface as shown in Fig. 1 for the bandsaw of the width not less than 50 mm, using a micrometer specified in **JIS B 7502**.

The variation of width and thickness shall be expressed with the difference between the maximum value and the minimum value out of the values measured on a single bandsaw.

6.2 Hardness The hardness shall be measured at any four places using a Vickers hardness testing machine specified in **JIS B 7725** in accordance with the test method specified in **JIS Z 2244**.

The variation in hardness shall be expressed with the difference between the maximum value and the minimum value out of the values measured on a single bandsaw.

6.3 Camber The maximum camber of the bandsaw relative to the datum line joining any two pints 6 m apart as shown in Fig. 1 shall be measured using a vernier calliper specified in **JIS B 7507** and take this maximum value as the camber.

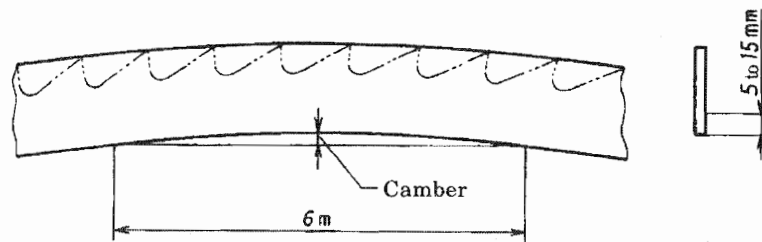


Fig. 1 Camber

7 Inspection Inspection shall be carried out on quality, shape and dimensions and the results shall conform to the requirements in **3** and **4**.

8 Designation of products The designation of products is given by the number of Japanese Industrial Standard or title of Standard, width and thickness.

Examples **JIS B 4803** 152×1.25

Bandsaw blade for woodworking 152×1.25

9 Marking The following information shall be marked on the products:

- a) Width (*W*) × thickness (*T*)
- b) Name of material or symbol
- c) Manufacturer's name or its abbreviation

Attached Table 1 Shape and dimensions



Shape of teeth is an example.

Unit: mm

Width		Thickness		Pitch ⁽¹⁾	Width		Thickness		Pitch ⁽¹⁾			
<i>W</i>	Tolerance	<i>T</i>	Tolerance	<i>P</i>	<i>W</i>	Tolerance	<i>T</i>	Tolerance	<i>P</i>			
6.3	<u>±1</u>	0.5	<u>±0.03</u>	4	40	<u>+2</u> <u>-1</u>	0.8	<u>±0.03</u>	10			
10		0.5		6.3	50		0.9		12.5			
		<u>0.55</u>		—	51		<u>0.55</u>		—			
		<u>0.65</u>					<u>0.65</u>					
		<u>0.7</u>					<u>0.7</u>					
12.5		0.6		6.3			0.8		12.5			
13		<u>0.55</u>		—			0.9					
		<u>0.65</u>					<u>0.7</u>					
		<u>0.7</u>					<u>0.8</u>					
16		0.6		6.3			0.9	<u>±0.04</u>	—			
		<u>0.65</u>		—			<u>0.8</u>					
		<u>0.7</u>					<u>0.9</u>					
		<u>0.8</u>					<u>1.05</u>					
<u>19</u>		<u>0.65</u>			102	<u>+4</u> <u>-2</u>	<u>0.65</u>					
		<u>0.7</u>					<u>0.7</u>					
		<u>0.8</u>					<u>0.8</u>					
		<u>0.8</u>					<u>0.9</u>					
20		0.5			127		<u>0.7</u>					
		0.7					8			<u>0.8</u>		
		<u>0.65</u>					6.3			<u>0.9</u>		
		<u>0.7</u>					—			<u>1.05</u>		
25	<u>+2</u> <u>-1</u>	0.5		6.3	152		<u>1.05</u>	<u>±0.05</u>				
		<u>0.65</u>		—			<u>0.9</u>					
		0.7		8			<u>1.05</u>					
		0.8		—			<u>1.25</u>					
		<u>0.9</u>		10	178		<u>1.05</u>	<u>±0.06</u>				
		0.7					<u>1.25</u>					
		<u>0.8</u>					<u>1.25</u>					
		<u>0.7</u>					<u>1.45</u>					
32		0.7		—	203		<u>1.25</u>	<u>±0.07</u>				
<u>0.8</u>		<u>1.45</u>										
<u>0.7</u>		<u>1.45</u>										
<u>0.8</u>		<u>1.45</u>										
<u>38</u>		0.7			255		<u>1.45</u>					
		0.8					<u>1.45</u>					

Note ⁽¹⁾ Pitch (P) is derived from **ISO 3295** and applies only to the shape of teeth shown in the Figure.

- Remarks
- Whether gear cutting is or not, and the pitch are decided by the agreement between the parties concerned.
 - The values underlined in the Table are the dimensions not included in the original International Standard.

Errata for JIS (English edition) are printed in *Standardization Journal*, published monthly by the Japanese Standards Association, and also provided to subscribers of JIS (English edition) in *Monthly Information*.

Errata will be provided upon request, please contact:
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